

Work Order ID 150572

Thursday, September 01, 2016 8:33:19 AM

150572

Page 1

Item ID: D4780-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Cover Mounting Bracket Assembly
Start Date: 9/1/2016 Start Qty: 7.00 ***7*** Cust Item ID:
Required Date: 9/1/2016 Req'd Qty: 7.00 ***7*** Customer:
Reference: rework - ECN16-562 *u*

Approvals: Process Plan: *u* Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4780	A

140

0.00

140

Small Fab

Memo

0.05

Small Fab

PULL FROM STOCK:
2 X D4780-041 B145827
5 X D4780-041 B147148

REMOVE NUT PLATES AND DISCARD

7x *16/02/01* *DAS 36 9-89*

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.02

Quality Control

7 *DAS 38 9-89*

SEP 06 2016

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				<u>7</u>			DAS 38 9-89 SEP 07 2016
190 *190* Small Fab Small Fab	1-RE- Install nutplate as per dwg Memo	0.00 0.05				<u>7</u>	<u>FF</u>		SEP 07 2016
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.02				<u>7</u>			DAS 38 9-89 SEP 08 2016

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Reference: rework - ECN16-562

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: 85125	0.00							
210						7	DAS 6 9-89		
Packaging	Memo	0.01							SEP 09 2016
Packaging	RE-IDENTIFY USING NEW B/N								
220	QC21- Final Inspection - Work Order Release	0.00					DAS 21 9-89		SEP 09 2016
220									
QC	Memo	0.12							
Quality Control							DAS 21 9-89		SEP 09 2016

Picklist Print

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Parent Item: D4780-041

D4780-041

Parent Item Name: Fwd Cover Mounting Bracket Assembly

Start Date: 9/1/2016

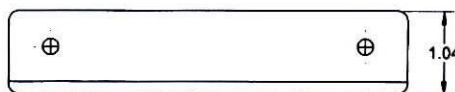
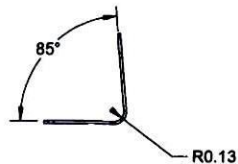
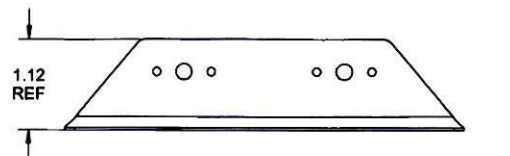
Required Date: 9/1/2016

Start Qty: 7.00

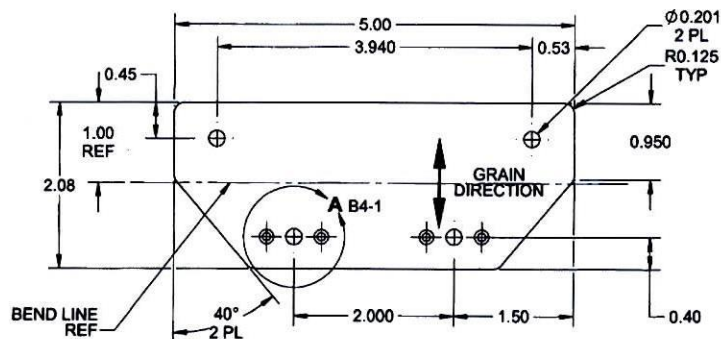
Required Qty: 7.00

Comments: IPP REV:A 13.03.13 NEW ISSUE DD VERF:JLM

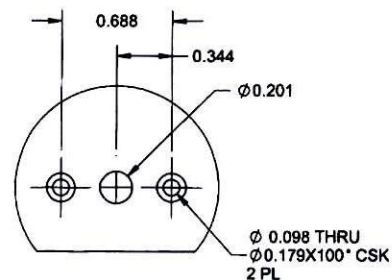
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4780-041		Manufactured	No				Each	7.0000		7	2x 145827 5x 147148		u 1609.4
D4780-041									**				
Fwd Cover Mounting Bracket Assembly													
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST125				7					
					148383			7					
MS20426AD3-4		Purchased	No				Each	4,507.000		28			
MS20426AD3-4									**				
RIVET													
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST312				4507					
					m134294			4507					
MS21059L3		Purchased	No				Each	104.0000		14			
MS21059L3									**				
Nut Plate													
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				CA				8					
					M129682			8					
				ST301				76					
					M135015			10					
					M135297			66					
				ST303				20					
					M133016			20					



D4780-1 FWD COVER MOUNTING BRACKET
(MAKE FROM D4780-1F)



D4780-1F FLAT PATTERN



DETAIL A B7-1
SCALE 2X
2 PL

D4780-1 FWD
COVER MOUNTING BRACKET

MS20426AD3-4 RIVET
2X, 2PL

MS21059L3
NUTPLATE
2 PL

D4780-041 FWD COVER MOUNTING BRACKET ASSY

RELEASED
2013-03-11

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032" THICK, PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 (REF. DART SPEC. M6061T6S.032)
- 2) FINISH: D4780-1F: NONE, D4780-1: CHEMICAL CONVERSION COATING PER DART QSI 005 4.1, POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3, D4780-041: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4780-041" AND B/N USING FINE POINT PERMANENT INK MARKER PER DART QSI 044 METHOD 6.1
- 7) WEIGHT: 0.02 lbs
- 8) PROFILE PER DRAWING FILE "D4780-1F-REVA.DXF"

QTY -041	P/N	DESCRIPTION
X	D4780-041	FWD COVER MOUNTING BRACKET ASSY
1	D4780-1	FWD COVER MOUNTING BRACKET
4	MS20426AD3-4	RIVET, CSK
2	MS21059L3	NUTPLATE

A NEW RELEASE		DB	13.03.01
REV.	DESCRIPTION		BY DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AB	DRAWING NO.	REV. A
MFG. APPR.	AB	D4780	SHEET 1 OF 1
APPROVED	AB	TITLE	FWD COVER MOUNTING BRACKET ASSY
DE APPR.	AB	SCALE	NTS
DATE	13.03.01	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ENGINEERING CHANGE NOTICE **DART AEROSPACE LTD**

Date:	16.04.15	Job No.:		ADR Yes/No:	N	ADR Date:	N/A	ECN #:	16- 562
Product No.:	D350-616	Created By:		Approved By:					
Product Name:	EMERGENCY LITTER KIT			Checked By:					

Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)	Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)
Director of Operations	N	DM		DQA / QA Coord.	Y	PS / ED	16.04.18
Production Manager / Coord.	Y	MP / MF	16-4-18	QC Coordinator	Y	PD	16.04.18
Purchasing Manager / Purchasing Coord.	N	LL / CL		Customer Support	Y	SW / LM	16.04.18
Production Engineering Coord.	Y	DD / JLM	16.04.18	Customer Technical Support	Y	MB / HS	16.04.18
Production Engineering Coord.	N	DL		Marketing	Y	SL / WR	16.04.18
Customer Order Processing	N	SL / BG		Dist. Management Coord.	Y	HM	16.04.18

Reason for Change:
PAR13-292, PAR15-415/446/467/474

Documents Affected:
RELEASE MDL-D350-616 Rev. D, IIN-D350-616 Rev. F, D350-616 Rev. H, ICA-D350-616 Rev. 2, D2341 and D2364 Rev. G, D3179 Rev. E, D5387 and D5388 Rev. A, and D4812 Rev. B

IF APPLICABLE: **NCR:** _____ **PAR:** Many **CAR:** _____ **CIR:** _____ **URF:** _____

PAPERWORK UPDATE ☒ **PARTS MUST COMPLY** ☒ **PREVIOUS PARTS SATISFACTORY** ☐

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	Y	MB	ADVISE CHL OF THE APPROVED CHANGE	16.04.18
2	Notify Eurocopter France	N			
3	Notify Augusta Westland	N			
4	Manufacturing Licensing Agreement Update	N			

#	Engineering Actions	Reqd	Resp	Notes	Complete
5	Required Documents/Drawings/Item ID's Under Review (URF)	N			
6	Update Master Document List (MDL)	Y	MB	MDL-D350-616 REV. D	16.04.18
7	Update Document Record (DR)	N			
8	Update Product Compatibility Matrix	N			
9	Notify TC / FAA of Change (eg. ICA, 8110-3)	N			
10					

#	Document Control Actions	Reqd	Resp	Notes	Complete
11	Move / Update Electronic Files / Design Journal	Y	KJ		16.04.18
12	Update Product Specification Files (Bluefiles)	Y	KJ		16.04.18
13	Update Approved/Preliminary Dwg PDF Files	Y	KJ		16.04.18
14	Update Product Development Summary (STC applications)	N			
15	Update QSI 021 (TC/FAA STC) and/or STC Approval List	N			
16	Create/Update Parts / STC Database	Y	KJ		16.04.18
17	Update / Verify Airworthiness Release Certificate Database	Y	KJ		16.04.18
18	Create / Update Change Record Form / Item Card Database	Y	KJ	SEE BELOW.	16.04.18
19	Create / Update Packaging Process Plan (PPP)	Y	KJ		16.04.18
20	Red Decals required on Packaging Process Plan (PPP)?	Y	KJ		16.04.18
21	Update Controlled Supplier Documents (Opulse) Database	N			
22	Update Grey Project Binder / Electronic Project Folder	Y	KJ		16.04.18
23	Update D-Part / M-Drawing / DSI / DEO Master Binders	Y	KJ		16.04.18
24	Update "Royalty Paid to" attribute (Parts sold under Dart USA STC's)	N			
25					

Description / Action:

- CHANGE NUMBER UPDATE: D350-616-011 NOW AT CHG 007, -013 NOW @ CHG 004, -015 NOW AT CHG 005
- D4779-041 NOW OBSOLETE AND REPLACED BY D5387-041
- D4778-1 NOW OBSOLETE AND REPLACED BY D5388-1
- UPDATE BOMS, ROUTES, FOR ALL D350-616-011/-013/-015 KITS IN STOCK
- CREATE BOMS AND ROUTES FOR D5387-041/-1/-1F AND D5388-1/-1F

147148
145827

ECN Verified & Complete: ON Date: APR 22 2016

Linda Lacelle

From: Marc Bellavance
Sent: Wednesday, August 31, 2016 8:19 AM
To: Linda Lacelle; Kim Johnston
Subject: RE: D4780-041

ECN16-562

From: Marc Bellavance
Sent: August-31-16 8:18 AM
To: Linda Lacelle <llacelle@dartaero.com>; Kim Johnston <kjohnston@dartaero.com>
Subject: RE: D4780-041

Hi Linda,

Both drawings still at Rev. A). From what I can tell, D4780-041 and D5387-041 were always meant to be black sandtex. If we have some in white then they are not in conformance with our drawings.

Marc

From: Linda Lacelle
Sent: August-31-16 7:53 AM
To: Marc Bellavance <mbellavance@dartaero.com>; Kim Johnston <kjohnston@dartaero.com>
Subject: FW: D4780-041

Hi Marc/Kim

Do you know if there was an ECN too change both of these to black? Both are still at Rev. A....?????

Thx
L

From: David Duval
Sent: Wednesday, August 31, 2016 7:42 AM
To: Linda Lacelle <llacelle@dartaero.com>
Subject: RE: D4780-041

D4780-041 and D5387-041 was updated to black sandtex in august 2016

DAVID DUVAL
Production Engineering Coordinator

From: Linda Lacelle
Sent: August-31-16 7:36 AM
To: David Duval <dduval@dartaero.com>
Subject: D4780-041

Hi David,

We have some of these in stores painted white, but the drwg says black sandtex, when was this changed? I see you updated the D5387 also...??

Thx
Linda